

Work Order ID 63328

Wednesday, October 27, 2010 3:47:58 PM



Page 1

Item ID:	D4038-4	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Angle, Aft, RH					
Start Date:	10/27/2010	Start Qty:	2.00			
Required Date:	11/11/2010	Req'd Qty:	2.00			
Reference:						

Approvals:	Process Plan:		Date:	10-10-28	Tooling:		Date:	
	QC:		Date:		SPC (Y/N):		Date:	

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4038	B								

100		Bandsaw	Jeaspa Bandsaw	0.00					
				0.00	aml 10/11/18	2	0		

Memo
Cut Blank 7.625" long

110		HAAS 1	HAAS CNC vertical machine #1	0.00					
				0.00	aml 10/11/23	2	0		

Memo
Mill as per Dwg & Folio FA880
Dwg Rev: B
Folio Rev: 44
Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63328

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Item ID: D4038-4

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle, Aft, RH

Start Date: 10/27/2010 Start Qty: 2.00

Required Date: 11/11/2010 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

amr 10/11/23

2

0

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

A.A 10/11/23

2

0

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QS1005 4.1

0.00

= JH 10/11/23

2

0

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Revision ID:

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

2 BR 10-11-23.

160



Packaging

Packaging

Identify as per dwg & Stock Location 87116

0.00

Memo

0.00

P 10/11/24 @

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/11/24

MF
10-11-24

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 63328



Parent Item: D4038-4



Parent Item Name: Angle, Aft, RH

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased	No			100	f	18.3871	0.7	1.473684			



6061T6 ANGLE 4.00 x 4.00 x .250

Location

Loc Qty

Loc Code

MAT

18.2187

→ 114507

18.2187

MAT06

0.1684

113391

0.1684

1.473 and 10/11/10

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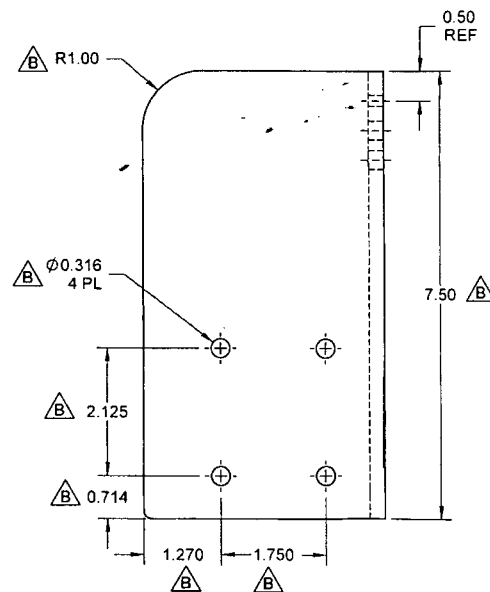
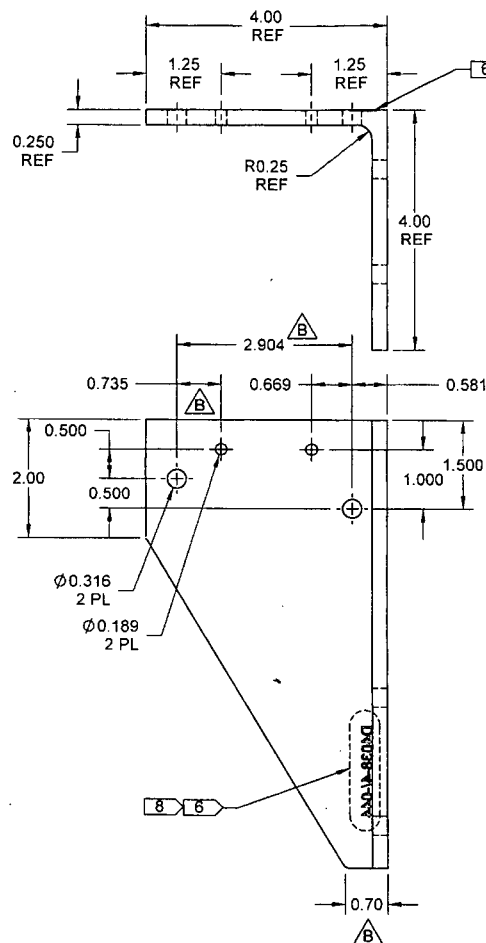
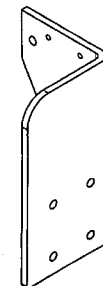
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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. *43328*
BS10-10-28



D4038-4 ANGLE, AFT, RH

RELEASED
 2010-04-14

- NOTES:
- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
 PER AMS-QQ-A-200/8
 REF DART SPEC M6061T6A4 000XW250
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (FAR SIDE ONLY) TO MAX
 DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
 - 7) WEIGHT: 1.19 lbs
 - 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. <i>B</i>
MFG. APPR.	<i>JS</i>	D4038	SHEET 6 OF 14
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	BRACKET	NTS
DATE	10.01.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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